

Work Order ID 75213

October-19-11 10:30:32 AM

75213

Page 1

Item ID: D205-564-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 19/10/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/10/19 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2521	Rev J

100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file and type labels per PPP D205-564-011 CHG008								

Handwritten: M 12 05 8
J Form LT 11-12-5
(8)

151	Pick Kit	0.00							
151									
Packaging	Memo	0.00							
Packaging									

Handwritten: SP 11-12 05

160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

Handwritten: M 11 12 05 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75213

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Page 2

October-19-11 10:30:32 AM

Item ID: D205-564-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 19/10/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>014</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

SP 11-12-05

11/12/06
me
11-12-06

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

October-19-11 10:30:37 AM

Page 1

Work Order ID: 75213

75213

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bearpaw

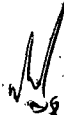
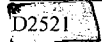


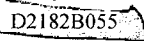


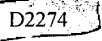


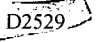

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP F00.01.20 Changed pick list, MPP 2019, CHG006EC
 IPP Rev:G 06-08-28 As per Rev E JLM
 IPP Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC
 IPP Rev:I 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
  *D2521*		Manufactured	No			151	Each	0.0000	 16				
Bearpaw 205									**	B 75263 SP.			
  *D2182B055*		Manufactured	No			151	Each	7.0000	 64				
Clamp-Cushion Black 5.5" Long									**	B 73932 SP.			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST402A				7					
				68746				7					
  *D2274*		Manufactured	No			151	Each	640.0000	 160				
Radius Block									**	SP B 74435 23x.			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST010				640					
				69736				5					
				72121				401					
				73389				234					
  *D2529*		Manufactured	No			151	Each	635.0000	 160				
Washer									**	SP 11-12-05			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST016				635					
				71161				250					
				73486				385					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October-19-11 10:30:37 AM

Page 2

Work Order ID: 75213

75213

Parent Item: D205-564-011

D205-564-011


Parent Item Name: Bearpaw

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 8.00

Required Qty: 8.00

 D2947
D2947
x8 Clamp

Manufactured No

151

Each

169.0000

8

64

**

SP

Location

Loc Qty

Loc Code

ST457

169

72134

60

73415

109

Manufactured No

151

Each

61.0000

4

32

**

LO4X

SP

B 76266 3x

Location

Loc Qty

Loc Code

ST457

50

72150

30

73301

20

ST458

11

68994

11

Purchased No

151

Each


1,144.000

8

64

**

SP 11-12-05

 AN4-13A
AN4-13A
x8 Bolt

Location

Loc Qty

Loc Code

ST357

1144

118078

590

118706

54

118838

500

LO4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

October-19-11 10:30:38 AM

Work Order ID: 75213

75213

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bearpaw

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 8.00

Required Qty: 8.00

AN4-15A

Purchased

No

151

Each

567.0000

20

160

AN4-15A

Bolt

**

SP m119449 121x.
m119749. 39x

Location

Loc Qty

Loc Code

ST358

567

118112

4

118648

263

118706

200

119127

100

AN960JD416

NAS1149D0463J

Purchased

No

151

Each

0.0000

20

160

AN960JD416

Washer

**

SP m119097. 132x.
28x m119078

MS21042L4

Purchased

No

151

Each

14,038.00

20

160

MS21042L4

Nut

**

SP 11-12-05.

Location

Loc Qty

Loc Code

ST300

3038

117441

51

117601

537

117885

56

118451

1394

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

160x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75213 M.C.J.

11/10/19

RELEASED

06 08.23 #

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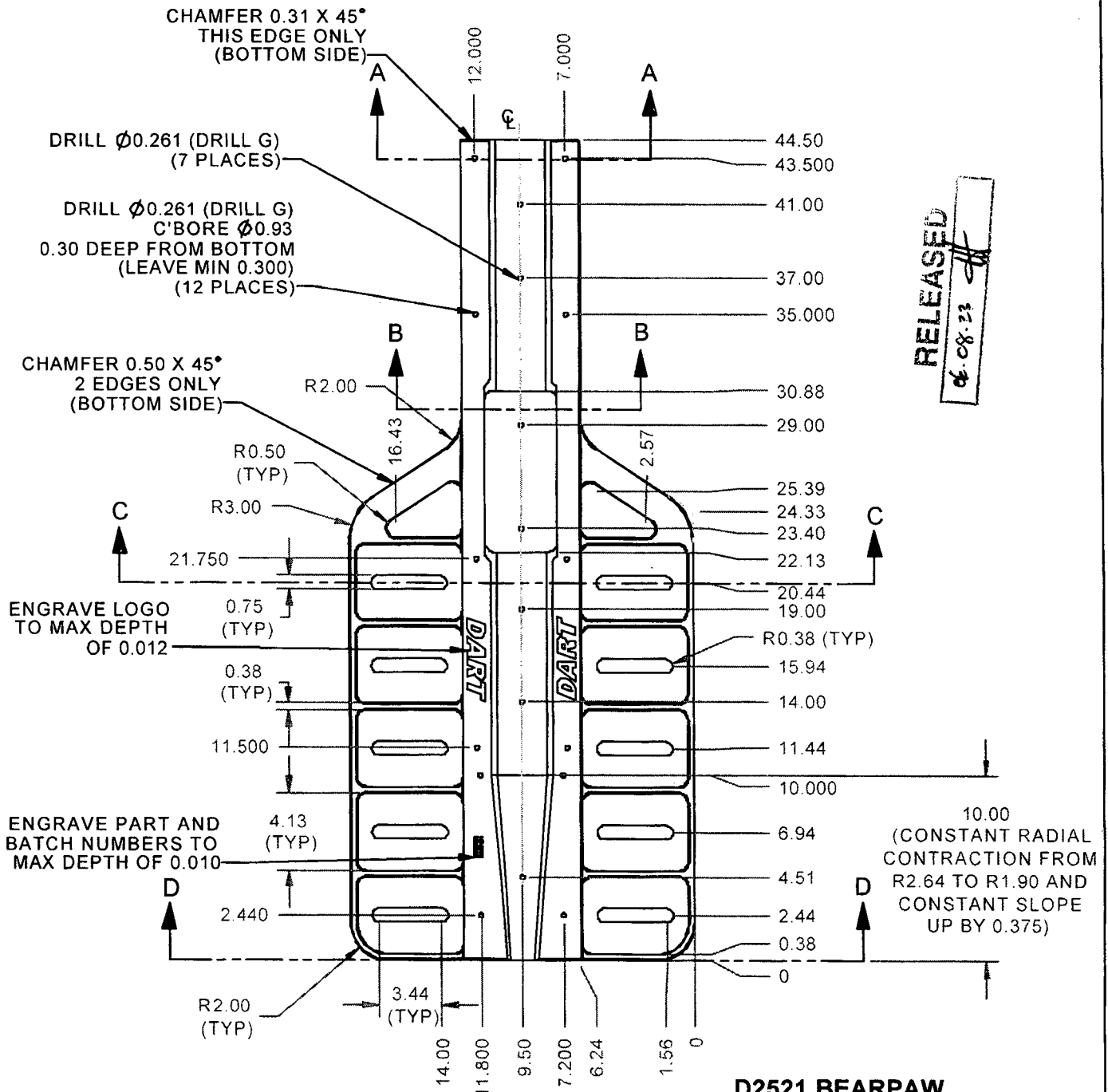
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
CP		D2521	SHEET 2 OF 3
DATE		TITLE	SCALE
06.07.28		205 BEARPAW	1:8

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

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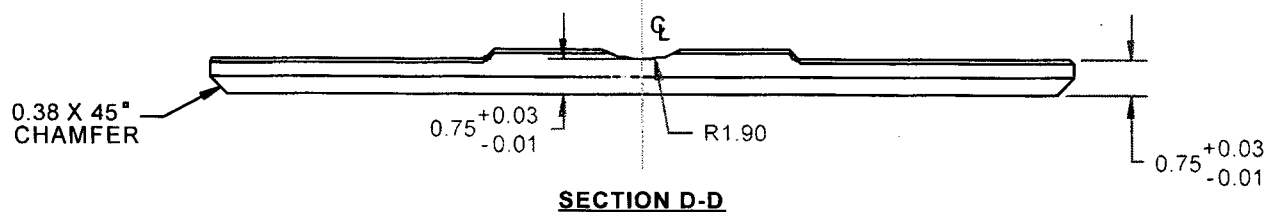
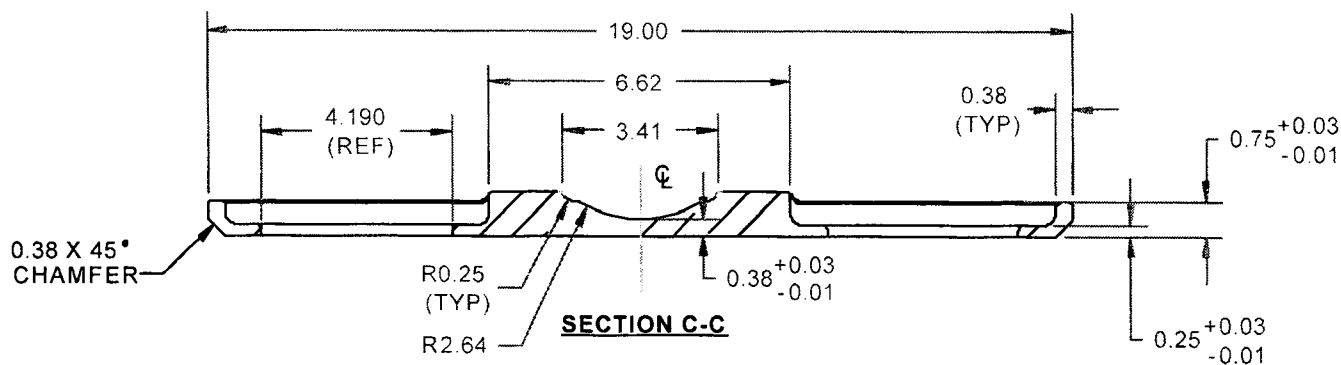
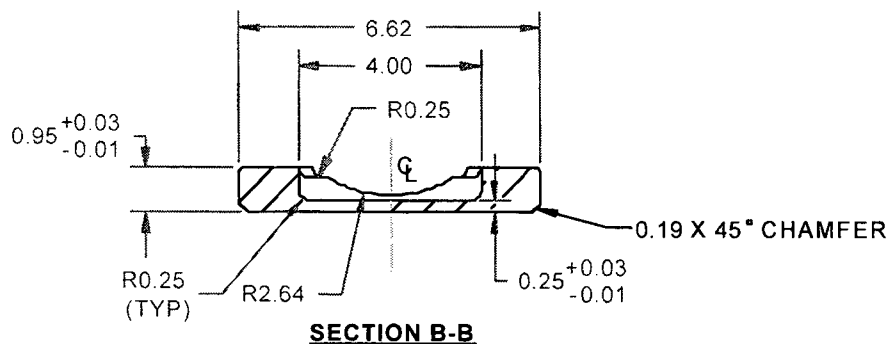
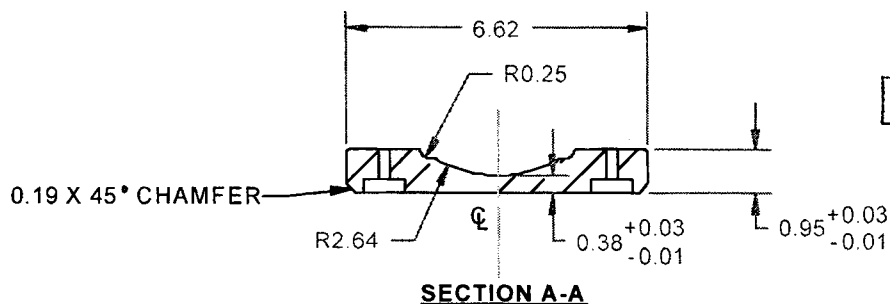
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	



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75213

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5.0 PARTS LIST

Qty	Part Number	Description
X	D205-564-011	BEARPAW INSTALLATION
8	D2182B055	RUBBER CUSHION
20	D2274	RADIUS BLOCK
2	D2521	BEARPAW
20	D2529	WASHER
8	D2947	CLAMP
4	D3544-041	CLAMP
8	AN4-13A	BOLT
20	AN4-15A	BOLT
20	AN960JD416	WASHERS
20	MS21042L4	NUT (OR MS21042-4)

Qty	Part Number	Description
X	DSI-9328-011	RUN-ON LANDING WEARPLATE KIT
2	D3511-041	WEARPLATE
16	AN4-17A	BOLT
4	AN4-11A	BOLT
4	AN970-4	WASHER
16	MS21042L4	NUT (OR MS21042-4)